Work Order ID 52575

October 2, 2009 7:47:09 AM

Item ID: D3960-3
Revision ID: A-PRELIM
Item Name: Cover
Start Date: 10/02/2009 **Start Qty:** 2.00
Required Date: 10/06/2009 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start

Stop

Cust Item ID: PRELIMINARY ISSUE
Customer:

Run Start

Stop

Approvals: **Process Plan:** MF **Date:** 09-10-02 **Tooling:** 0 **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Draw Nbr	Revision Nbr
D3960	A-PRELIM

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	cut as per dwg D3960 Dwg Rev: PRE Prog Rev: LiM								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

IB 9-10-5

IB 9-10-5

Scrap

ENGINEERING APPROVAL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52575

October 2, 2009 7:47:09 AM

Item ID: D3960-3 **Accept** **Setup Start** **Stop**

Revision ID: A-PRELIM

Item Name: Cover

Start Date: 10/02/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/06/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Brake NC	**Memo**	0.00							
Brake NC	Bend as per dwg D3960								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo** ENGINEERING APPROVAL	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 52575

October 2, 2009 7:47:09 AM

Item ID: D3960-3
Revision ID: A-PRELIM
Item Name: Cover

Accept

Setup Start
Stop

Start Date: 10/02/2009 **Start Qty:** 2.00
Required Date: 10/06/2009 **Req'd Qty:** 2.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	ENGINEERING APPROVAL Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:_____	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

send to Harvey Calgary.
Eagle single.

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

MF 09-12-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

October 2, 2009 7:47:08 AM

Work Order ID: 52575

Parent Item: D3960-3RevA-PRELIM

Parent Item Name: Cover

Comments:

Start Date: 10/02/2009 **Required Date:** 10/06/2009

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	114.0568	0.6968			
6061-T6 .040 Sheet											89-105	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	114.0568		
100742	3.3		
102723	7.93		
105842	12		
106747	12.5		
107461	13.1642		107461
109396	22.28		
111224	41.3826		
19380	1.5		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	52575
Description: COVER	Part Number:	D3960-3
Inspection Dwg: D3960-3 Rev: PRELIM		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 -.001	.102	X			
.31	+/- .030	.306	X			
4.00	+/- .030	4.005	X			
1.00	+/- .030	1.002	X			
6.43	+/- .030	6.431	X			
6.57	+/- .030	BF_ND				
7.81	+/- .030	7.821	X			
.09	+/- .030	.089	X			
5.11	+/- .030	5.109	X			
1.03	+/- .030	1.037	X			
6.36	+/- .030	6.333	X			
.92	+/- .030	.900	X			
4.64	+/- .030	4.637	X			
5.61	+/- .030	5.612	X			
6.38	+/- .030	6.355	X			
.040	+/- .010	.039	X			

Measured by:	IB
Date:	9-10-5

Audited by:	
Date:	

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Receiving Report

Date: 8/3/18

Supplier: CAM PI

Batch No: M107461

Dart P/O: A58558

Packing Slip: Yes ✓ No ___

Invoice: Yes ___ No ✓

Receipt: Cash ___ Cr ___

Release Note Attached: Yes ___ No ✓ N/A ___

Waybill Attached: Yes ___ No ✓

Shipment Complete: Yes ___ No ✓ N/A ___

QC6 Inspection 8/3/18 N/A ___

Work Order ___

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M3047R 1000LW 045		20	0	0	2	
M4147M3062.5X040W		12	0	0	12	

Initials of receiver (if shipment OK) Level 12

Location ___

Production/Admin: Date Received/Costing Initial 08/03/18 RCS 1417 CS

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

pace Ltd
Ltd
n St
Ontario K6A 1K7
(613) 632-3336
(613) 632-4443

Receiving Slip

Date	Page
Mar 25, 2008	1

Receipt Number
RCP00007417

Purchase From:

Campi Steel
935 Boul. Du Havre
Valleyfield, QC J6S 5L1

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00005858

Vendor Item Number	Part Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M2024T3S040	2024-T3 .040 sheet	144.0000	sf	8.750000	1,260.00	Mar 25, 2008
		PER AMS-QQ-A-250/4 OR AMS 4037 MATERIAL: 2024-T3 ALUMINUM SHEET B/N107461					
	M6061T6B1500X0	6061-T6 Bar 1.5" x 1.25"	48.0000	f	7.900000	379.20	Mar 25, 2008
		MATERIAL AS ABOVE B/N107461					
	M6061T6S040	6061-T6 .040 Sheet	144.0000	sf	2.100000	302.40	Mar 25, 2008
		PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SHEET B/N107461					

Comments:

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
For:

Mark J Vrablec
Director of Manufacturing Davenport Works

Kenton F. Young
Quality Assurance Manager

Ship Date	B.L. No.	Invoice No.	Alcoa No Item
834417 0			
2007-10-04	2555463	00000	4810133-2

P.O. No./Govt Contract No.	Customer	Mfg Order
N20013		

Ship To:

Item Description
0.04 IN TK (+0 -.0035) X 48.0 IN W (+.046875 -.046875) (M) A/T 6061-T6 COIL SHEET PER DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 AMS4027 REV M IS 2007 ASTMB209 REV 06 CMMP025 REV Q CMMP019 REV D CSTI008 REV D ((NOT MARKED)) COIL SIZES: ID 20 IN COIL WGTS: MAX 7000 LB MAX GROSS SKID WGT: 10000 LB QUAN TOL +/-30 % CQR 0213054 REV 01 CUST REQ 07-09-15 *** W/E 07-10-06 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	568624	360714	5327	1	PC	:
2	568627	360714	5197	1	PC	:
			10524	2		

Notes for CQR: 0213054.1
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD UCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.
Exception to Spec CMMP025 ; Revsn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .
Exception to Spec CMMP019 ; Revsn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .
Exception to Spec CSTI008 ; Revsn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0213054.1 -Specification Limits

Tmpr	Dir		UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.	Max			
		Min	42.0	35.0	10

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
Alloy 6061	Min	0.40		0.15		0.8	0.04					REMAIN

Lot: 360714 - Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	No->	UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.	Test 2	50	41.2	13
			49.0	41.2	13.5

CERTIFICATE OF COMPLIANCE

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the materials covered by this certificate have been completed with, and have been found to meet, the requirements of the purchase order/contract listed below except as noted. Where applicable, deviations in meeting a part of the description and that samples have been submitted or tests made that meet the specifications listed and found on permanent file/records shown on the face of this sheet.

Kaitlin P. Young
Quality Assurance Manager

Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	Page 2
834417	0			
2007-10-06	2555463	00000	4810133-2	

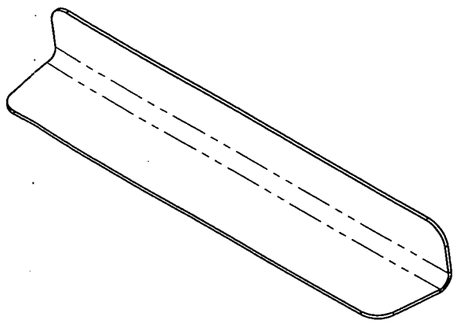
P.O. No./Govt Contract No. Customer Mfg Order

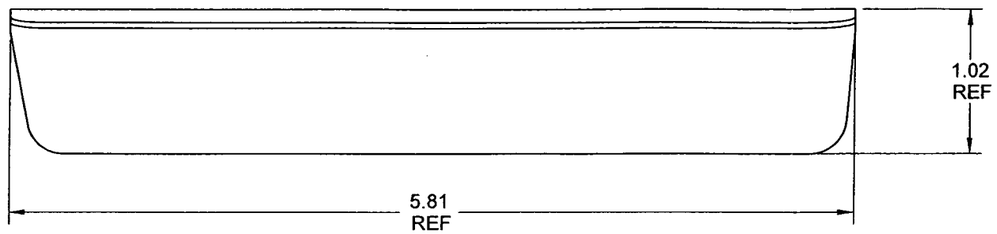
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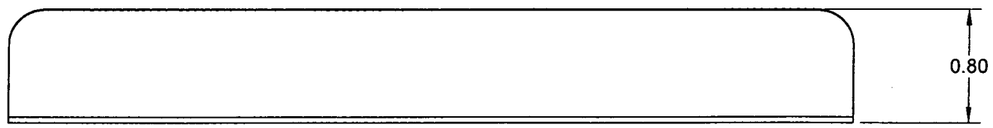
Part: 160914 Mechanical, Physical, Metallograpy, Quantometer Results (cont.)

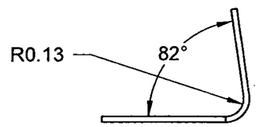
Heat Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
HH0010A4	Analysis	0.06	0.5	0.17	0.06	0.9	0.19	0.06	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States









D3960-1 ANGLE
MADE FROM D3960-1F

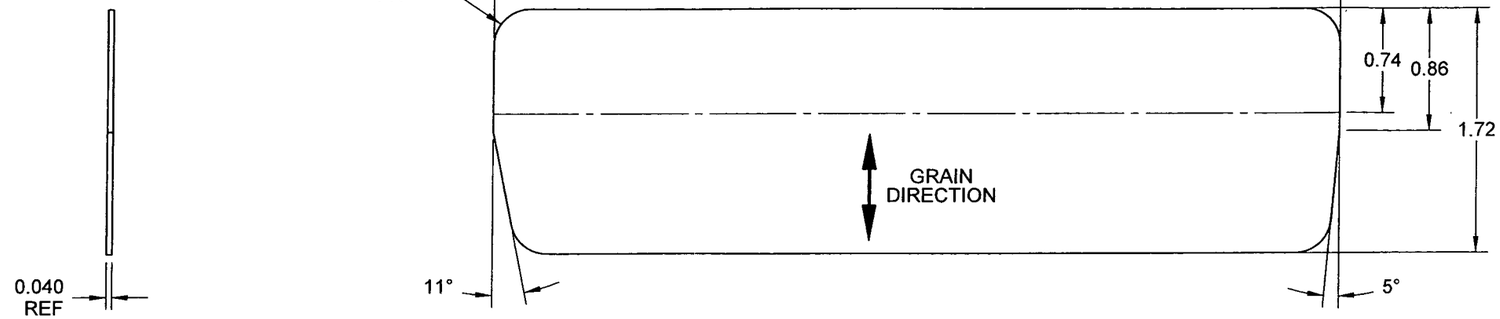
PRELIMINARY ISSUE
29/10/01

NOTES:
1) MATERIAL: MADE FROM D3960-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3960-1" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.04 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.10.01

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3960 REV. A
MFG. APPR.		SHEET 1 OF 4
APPROVED		TITLE ANGLE SCALE NTS
DE APPR.		
DATE	09.10.01	

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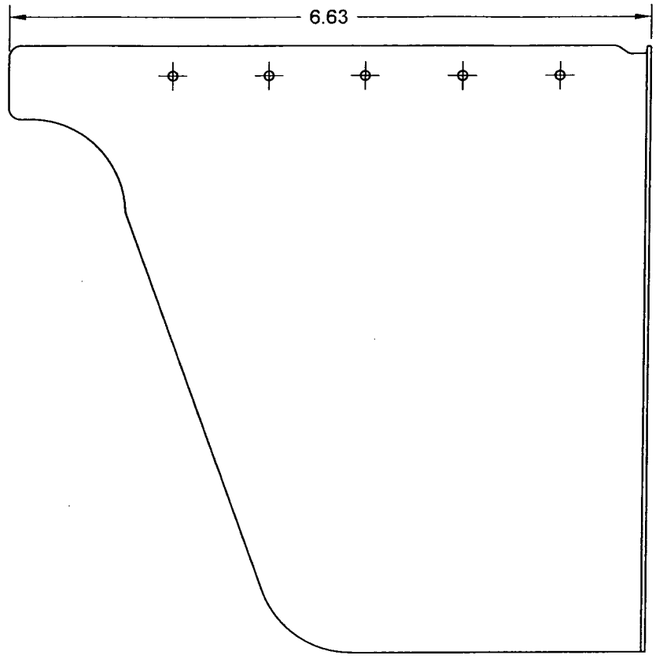
D3960-1F FLAT PATTERN

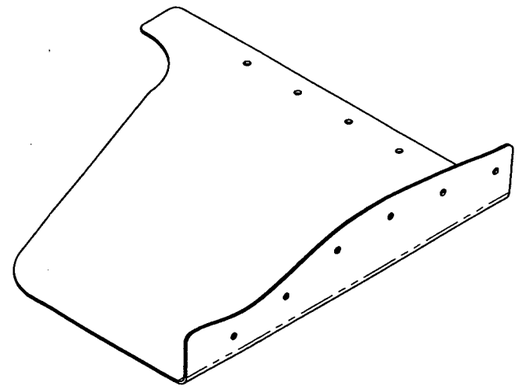
PRELIMINARY ISSUE
MP 09/10/01

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.04 lbs

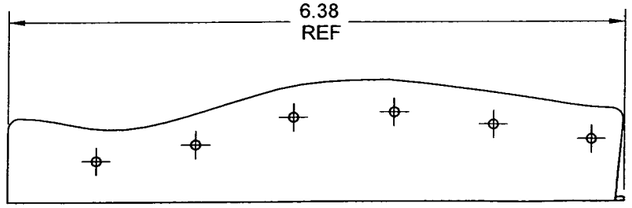
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3960 REV. A
MFG. APPR.		SHEET 2 OF 4
APPROVED	MP	TITLE ANGLE SCALE NTS
DE APPR.		
DATE 09.10.01		

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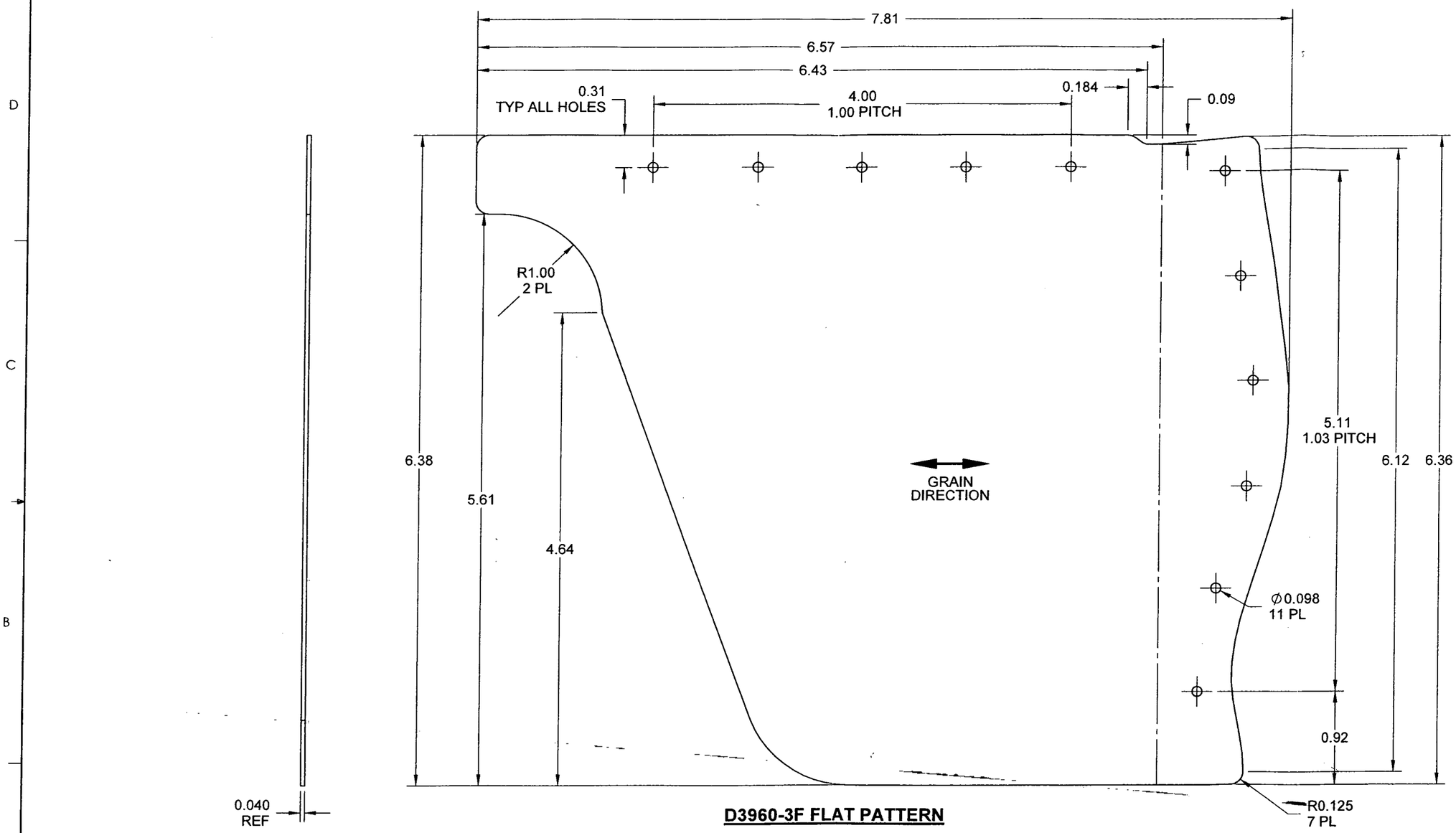
PRELIMINARY ISSUE
09/10/01

D3960-3 COVER
MADE FROM D3960-3F

NOTES:
1) MATERIAL: MADE FROM D3960-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3960-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.05 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3960 — REV. A
MFG. APPR.		SHEET 3 OF 4
APPROVED		TITLE ANGLE — SCALE NTS
DE APPR.		
DATE 09.10.01		

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D3960-3F FLAT PATTERN

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs

PRELIMINARY ISSUE
MP 09/10/01

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3960 — REV. A — SHEET 4 OF 4
CHECKED		TITLE: ANGLE — SCALE: NTS
MFG. APPR.		
APPROVED	MP	
DE APPR.		
DATE 09.10.01		

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